

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015557**Date Inspected:** 09-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao / Geng wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#14

SAW welding of weld joint 1G-004 located on PCMK LD3031-001 for Lift 13 the welder is identified as 045265. ZPMC QC is identified as Mr. Lv Liqian. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-L2c-S-2.

FCAW welding of weld joint 2F-078 located on PCMK SP3072-001 for Lift 13 the welder is identified as 201215. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2132.

SMAW welding of weld joint 3G-177 located on PCMK SEG3004J for Segment 12AW the welder is identified as 047864. ZPMC QC is identified as Mr. Wang wei ming. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2213-Tc-U4b-FCM-1.

Visual inspection of weld joint fit-up dimension and tack weld checked with ZPMC QC Mr. Lv Liqian the weld joint is identified as LD3033-001-001 is appeared to comply with the WPS.

OUTSIDE SHOP

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SMAW welding of weld joint 4G-004 located on PCMK SEG074A for Segment 11EE the welder is identified as 054013. ZPMC QC is identified as Mr. Wu shi gao. The welding variables recorded by QC appeared to Comply with the WPS-B-P-2214-B-U2-FCM-1.

Fit-up of drip plate with side plate is in progress on counter weight side of segment 11DW.

BAY#16

SAW welding of weld joint 1G-004 located on PCMK BP3075-001or Segment 13AW the welder is identified as 045270. ZPMC QC is identified as Mr. Tao wei. The welding variables recorded by QC appeared to Comply with the WPS-B-T-2221-B-U3c-S-2.

Fit-up of bottom plate splice weld for segment 13AW is in progress the weld is identified as BP3074-001-002.

BAY#19

This QA inspector performed 15% MT of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG Bike path BK004A-011. The weld designations reviewed as follows.

BK004A3-011-025,026,051,052.

BK004A4-011-014,066,067.

BK004A5-011-056,057,078,079,080,081.

BK004A6-011-031,033,041,042.

BK004A7-011-140,141,169,184,185,199,129,144,167,182,183,198,067,068,073,074,079,080,013,014,025,026,007,008,230,217,224.

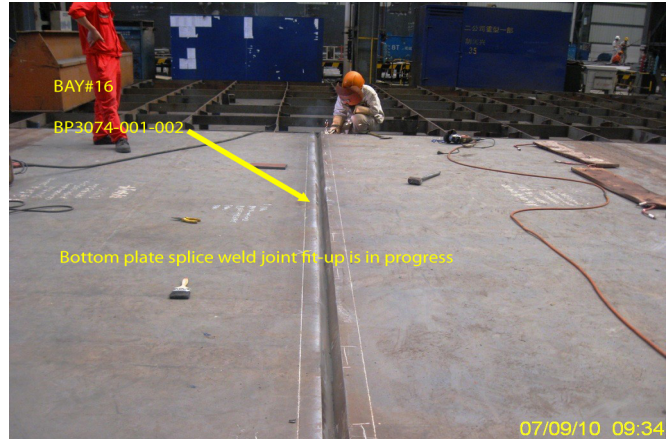
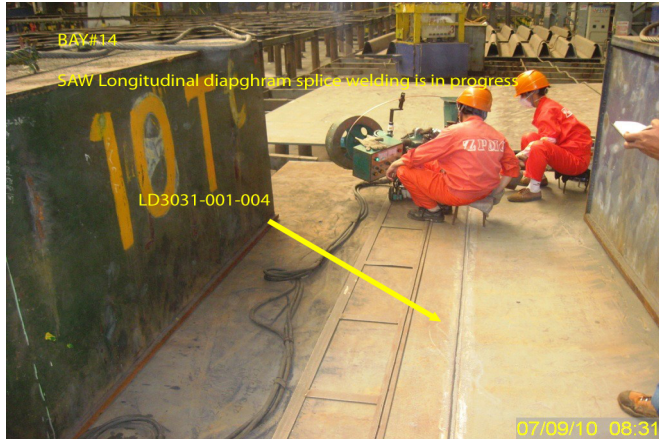
BK004A8-011-041,042.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant Conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Chadra	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
